



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5466-1

Job Sheet 198586



Part No: D5466-1

Job Qty: 8 pcs

Part Name: Saddle, Fwd, In



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/31/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 9/9/19

Description:

Note: IPP Rev.A 17.07.12 New issue DP Verify DD IPP Rev.B 17.11.03 AS PER DWG REV.A DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Machining - Issue SN	8 pcs	9/9/19	9/9/19	0.00	0.00	HAAS - 1		SBL 19/11/19
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
100	HAAS 4 Axis - B4B	8 pcs	9/9/19	9/9/19	3.00	6.90	HAAS - 1 - B4B		SBL 19/11/19
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	8 pcs	9/9/19	9/9/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		



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Container No: S229611



Part: D5466-1

Job No: 198586

Serial No/Batch: S229611

Revision: A

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/08/19

Plex 7/31/19 7:52 AM Dart.lajeunesse.marie

130 QC 8	8 pcs	9/9/19	0.00 0.00	QC 2 - 57	SBL 19/11/19
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
140 Handfinish - 1-1 Chemical- B4B	8 pcs	9/9/19	0.00 1.02	QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	NOV 11 2019
				Handfinish - 1 - 4 - B4B	
150 Spray Paint - 2 - B4B	8	9/9/19	0.00 0.36	Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
				Spray Paint - 1 - B4B	

			pcs		Spray Paint - 2 - B4B	
					Spray Paint - 3 - B4B	
					Spray Paint - 4 - B4B	
160	QC 14	8	9/9/19	0.00 0.00	QC 14 - 15	
		pcs			QC 14 - 2	
					QC 14 - 34	
					QC 14 - 41	
					QC 14 - 51	
					QC 14 - 58	
					QC 14 - 59	
					QC 14 - 9	
					QC 14 - 68	
					QC 14 - 40	
					QC 14 - 19	
					QC 14 - 43	
					QC 14 - 24	
					QC 14 - 61	
					QC 14 - 81	
170	Packaging 3-1 - Stock - B4B	8	9/9/19	0.00 0.00	Packaging 3 - 1 - B4B	
		pcs			Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
180	QC 21 - SA	8	9/9/19	0.00 0.00	QC 21 - SA - 21	
		pcs			QC 21 - SA - 70	
					QC 21 - SA - 53	

RQ 14-11-11

DAS

NOV 12 2019 68

9-89

DAS

28

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DAS

21

9-89

NOV 14 2019

Part Op 100 - (HAAS CNC Vertical Machine) Program Batch No. 502967 Double check by: [Signature] 1-Machine Step No 1 per
 Descriptions: Folio FB551 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FB551 and inspect per attached

Dimension Sheets 3-Machine Step No 3 per Folio FB551 and insp

120 - (QC2- Inspect parts off machine FAI/FAIB)

130 - (QC8- Inspect parts - second check)

140 - (Chemical Conversion Coat per QSI005 4.1)

150 - (Spray Paint / NDT Room) ***MASK HOLES PRIOR TO PRIME AND PAINT AS PER DWG NOTE 8*** 1-PRIME AS PER DWG AND QSI005 4.2.1.3.3 PRIMER BATCH: 5200299 2-PAINT AS PER DWG AND QSI005 4.2.2.4

PAINT BATCH: 5213125

160 - (QC14- Inspect Spray Paint)

170 - (Identify as per dwg & Stock Location: _____)

180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-005	Saddle Billet	8 pcs (1 ea)	90-Machining - Issue SN	5200299

5204755

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Machining - Issue SN	D6101-005	8	26	0

Part Specifications

Specifications could not be found.

Plex 7/31/19 7:52 AM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order: 198586
Description: Saddle, Fwd, In		Part Number: 05466-1
Inspection Dwg: 05466-1	Rev: A	DSK: Rev: Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.438	0.443 ^{mm}		.438	.438	.438	.438	.438
B	1.745	1.755 ^{mm}		1.750	1.750	1.750	1.750	1.750
C	3.495	3.505 ^{mm}		3.500	3.500	3.500	3.500	3.500
D	1.745	1.755 ^{mm}		1.750	1.750	1.750	1.750	1.750
E	7.990	8.010 ^{mm}		7.997	7.997	7.997	7.997	7.997
F	0.490	0.510		.497	.498	.498	.498	.497
G	0.257	0.262		0.257	0.257	.257	.258	.258
H	0.375	0.380		0.375	0.375	.375	.375	.375
I	0.490	0.510		0.500	.497	.498	.498	.497
J	1.174	1.184		1.180	1.180	1.179	1.174	1.179
K	0.558	0.578		0.566	.565	.566	.566	.566
L	1.174	1.184		1.180	1.179	1.179	1.179	1.179
M	1.490	1.500		1.496	1.495	1.495	1.495	1.495
N	2.495	2.505		2.500	2.500	2.500	2.500	2.500
O	3.869	3.879		3.874	3.874	3.874	3.874	3.874
P	0.115	0.135		0.135	.135	.133	.132	.132
Q	0.115	0.135		0.1245	0.1235	.124	.124	.124
R	0.240	0.260		0.250	0.250	.250	.244	.249
S	0.115	0.135 ^{mm}		0.130	.128	.129	.130	.130
T	0.178	0.198		0.188	0.188	.188	.188	.188
U	2.940	2.980		2.961	2.961	2.960	2.960	2.960
V	0.230	0.250		0.241	.241	.241	.240	.241
W	0.115	0.135		.130	.130	.129	.129	.130
AI	2.000	2.020 ^{mm}		2.000	2.000	2.000	2.000	2.000
Z	0.352	0.372		.368	.366	.367	.367	.367
AA	0.470	0.530		0.500	0.500	.500	.500	.500
AB	0.615	0.635		0.622	.622	.621	.622	.622
AC	0.053	0.073		0.063	.061	.062	.063	.063
AD	0.240	0.260		0.245	.249	.249	.249	.249
AE	1.375	1.395 ^{mm}		1.385	1.385	1.385	1.385	1.385
AF	0.115	0.135 ^{mm}		.135	.135	.135	.135	.135
AG	0.240	0.280		0.265	.265	.265	.265	.265
AH	0.240	0.260		.252	.253	.252	.253	.253

Accept/Reject

Measured by: <i>[Signature]</i> SBL	Date: 11/11/7
Audited by:	Date:
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.11.08	Reformat	KJ/JLM	
C	12.07.31	Prototype revised to preliminary	KJ	

DART AEROSPACE LTD		Work Order: 198586
Description: Saddle, Fwd, In		Part Number: 05466-1
Inspection Dwg: 05466-1	Rev: A	DSK: Rev: Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				#6	#7	#8	4	5
A	0.438	0.443		.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750		
E	7.990	8.010		7.997	7.997	7.997		
F	0.490	0.510		.497	.498	.498		
G	0.257	0.262		.258	.258	.258		
H	0.375	0.380		.375	.375	.375		
I	0.490	0.510		.497	.497	.497		
J	1.174	1.184		1.179	1.179	1.179		
K	0.558	0.578		.565	.565	.565		
L	1.174	1.184		1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874		
P	0.115	0.135		.132	.133	.132		
Q	0.115	0.135		.125	.124	.124		
R	0.240	0.260		.250	.249	.249		
S	0.115	0.135		.129	.130	.130		
T	0.178	0.198		.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960		
V	0.230	0.250		.240	.240	.240		
W	0.115	0.135		.130	.130	.131		
AI	2.000	2.020		2.000	2.000	2.000		
Z	0.352	0.372		.367	.367	.368		
AA	0.470	0.530		.500	.500	.500		
AB	0.615	0.635		.622	.622	.622		
AC	0.053	0.073		.063	.063	.061		
AD	0.240	0.260		.249	.248	.249		
AE	1.325	1.395		1.385	1.385	1.385		
AF	0.115	0.135		.135	.135	.135		
AG	0.240	0.280		.265	.260	.260		
AH	0.240	0.260		.252	.253	.252		
Accept/Reject								

Measured by: SBL	Date: 12/11/11
Audited by:	Date:
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.11.08	Reformat	KJ/JLM	
C	12.07.31	Prototype revised to preliminary	KJ	

